

Date: Wednesday, 4/19/2006 7:36:55 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 26709	
Estimate Number : 10393	
P.O. Number : N/A	Part Number : D31461
This Issue : 4/19/2006 S.O. No. : N/A	Drawing Number : D3146 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 24684	Material : N/A
Written By : <i>SLA comment below</i>	Due Date : 5/5/2006 Qty: 10 Um: Each
Checked & Approved By : <i>06/04/19</i>	
Comment : Est 04.04.28 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X04500	6061-T6 Bar 1.25" X 4.5"
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Comment: Qty.: 0.2932 f(s)/Unit Total : 2.9316 f(s)
 Material: 6061-T6/T651 (QQ-A-200/8) 1.250" thick
 (M6061T6B1.250x04.500)
 Batch: *M13655*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 4.500" x 1.250" x 3.100" long Bar

SL 06/04/25 *10*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA419 and Dwg D3146
 Identify as D3146-1

SL 06/04/26 *10*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SL 06/04/26 *10*

5.0	QC8	SECOND CHECK
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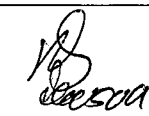
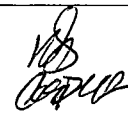
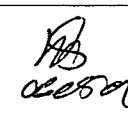


Comment: SECOND CHECK

SL 06/04/26 *10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/20	3	- 2 parts scrapped - parts lifted while machining on 3rd op. - dimension .125 is under by .015		Scrap + replace	SL 06/04/20			

NOTE: Date & initial all entries

Date: Wednesday, 4/19/2006 7:36:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 26709

Part Number: D31461

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr and Tumble

J.L 06/05/01 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M 06-05-01 (10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/05/01 (10)

9.0

Q05

INSPECT WORK TO CURRENT STEP



Comment: Inspect work to Step 9

QL3

06-05-02 10

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57410

AP 06/05/00 (10)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/00 (10)

Job Completion



06-05-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26709
Description: Bracket		Part Number:	D3146-1
Inspection Dwg: D3146	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.000	+/-0.010	3.004	✓			
2.000	+/-0.010	1.998	✓			
0.230	+/-0.010	.232	✓			
0.425	+/-0.010	.425	✓			
3.420	+/-0.010	3.423	✓			
2.535	+/-0.010	2.536	✓			
0.221	+/-0.010	.220	✓			
0.391	+/-0.010	.388	✓			
0.221	+/-0.010	.220	✓			
0.850	+/-0.010	.850	✓			
R0.350	+/-0.010	.350	✓			
0.850	+/-0.010	.850	✓			
0.221	+/-0.010	.220	✓			
0.491	+/-0.010	.488	✓			
0.125	+/-0.010	.130	✓			
1.025	+/-0.010	1.022	✓			
R0.375	+/-0.010	1.375	✓			
28°	+/-0.1°	28°	✓			
0.276	+/-0.010	.286	✓			
0.925	+/-0.010	.919	✓			
R0.125	+/-0.010	.125	✓			
4.345	+/-0.010	4.346	✓			
0.125	+/-0.010	.129	✓			
93°	+/-0.1°	93°	✓			
R0.125	+/-0.010	.125	✓			
Grain Direction	N/A					

Measured by:	SL	Audited by:	me	Prototype Approval:	N/A
Date:	06/04/26	Date:	06/04/26	Date:	N/A

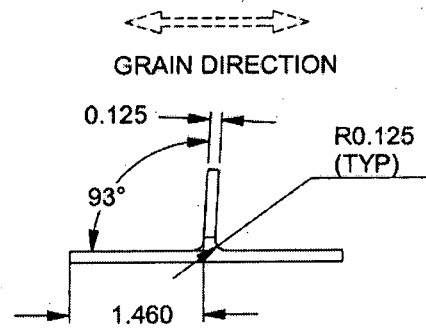
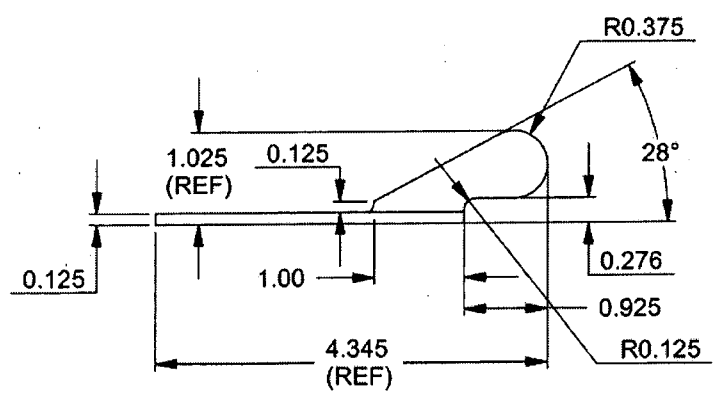
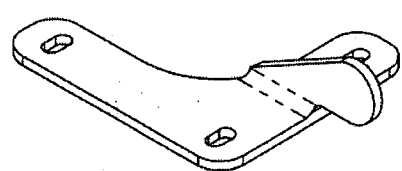
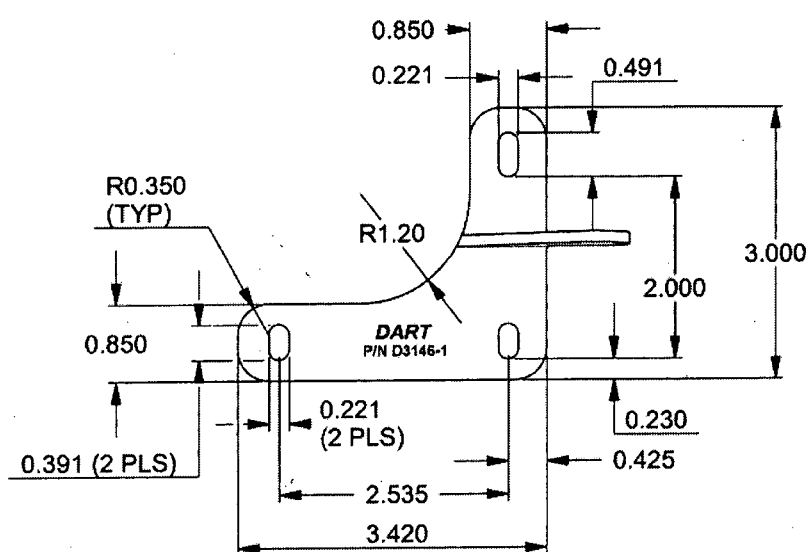
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	AS

DART



DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3146	REV. A SHEET 1 OF 1
DATE 02.04.25	TITLE BRACKET	SCALE 1:2	
A	02.04.25	NEW ISSUE	

RELEASED
02.05.27



D3146-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-27
(D3146-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-28)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC M6061T6B)
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26709

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